

split 26-p 25/09

Date: Friday, 22/08/2008 2:02:20 PM  
User: Julie Lecocq

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 1/4 TURN FASTNER RAIL (BLACK)
Job Number	: 41592		
Estimate Number	: 10096		
P.O. Number	:	Part Number	: D103858B
This Issue	: 22/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D1038
First Issue	: 11	Project Number	: N/A
Previous Run	: 38022	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>JUD 08.22</u>	Due Date	: 16/09/2008
Comment	: Est: E 03.05.02 Reformat; Added label KJ/RF Est Rev: F 06-08-16 Updated Packaging Procedures JLM		

Qty: 100 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUD 08/9/07



Comment: DOCUMENT CONTROL  
Create white labels and bag them

2.0 D2023 Extrusion, Fastener Rail



Comment: Qty.: 1.9030 f(s)/Unit Total: 190.3000 f(s)  
Extrusion, Fastener Rail

B21907

J.F. 08/09/07

110

3.0 BAND SAW BAND SAW



Comment: BAND SAW  
Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

J.F. 08/09/08

110

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
1-Machine as per Folio and Dwg D1038-58

DJP 08/09/09

110

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 08/09/09

110





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6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES  
Issue P/O: 7224  
Black Anodize as per Dwg D1038

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389

Batch: 1104298

2-Grind wire flush and deburr

3-Clean





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Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*50809/25 ELO*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: \_\_\_\_\_

*10X*

*8/9/25*

*50*

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/09/25*

Job Completion



*u 08.09.25*











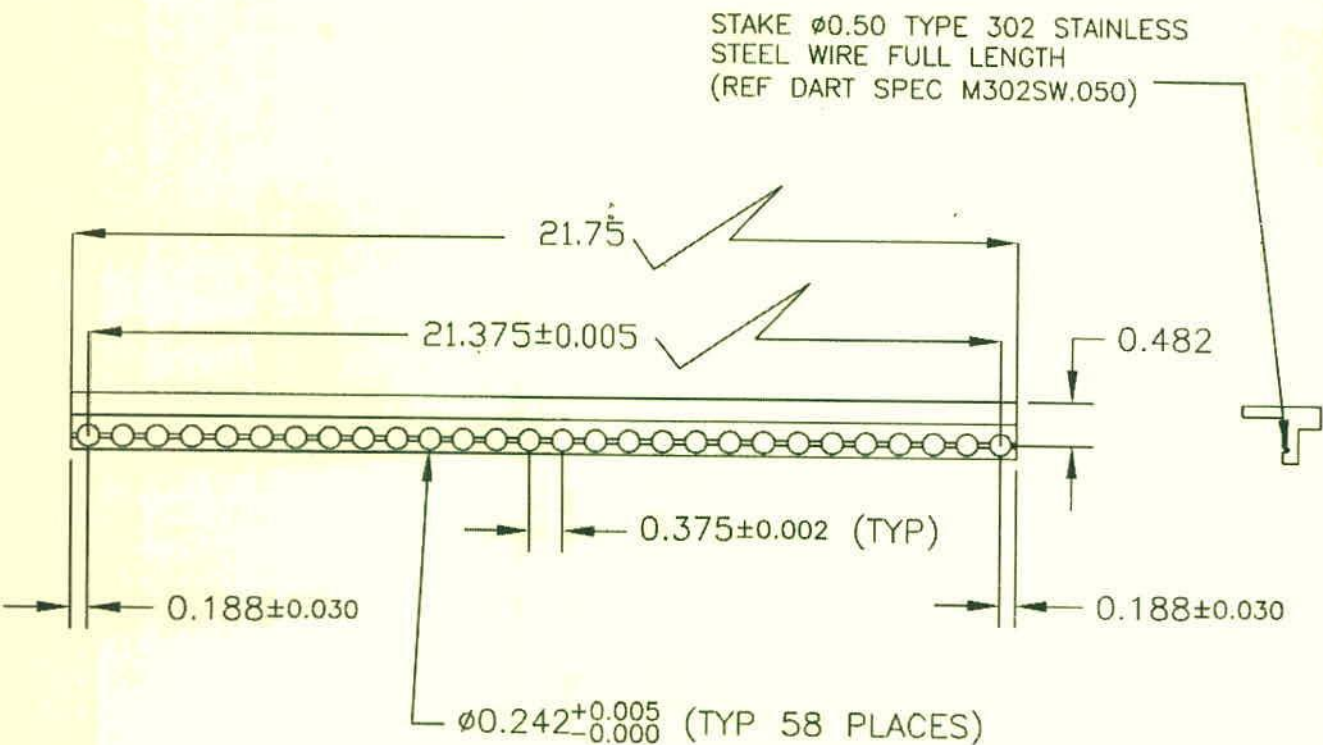
**DART**

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

RELEASED

05.03.31

DESIGN	DRAWN BY	DRAWING NO.	REV. B
44	SL	D1038	SHEET 1 OF 1
CHECKED	APPROVED	TITLE	SCALE
44	44	1/4 TURN FASTENER RAIL	NTS
DATE			
05.02.02			
	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	



**D1038-58 1/4 TURN FASTENER RAIL**

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE  
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES  
ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) SUBJECT TO AMENDMENT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
WITHOUT NOTICE  
WORK ORDER  
NO. 41542



**TNM****ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

PACKING

SLIP

68350

23-Sep-2008

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**NO. DE COMMANDE:****PURCHASE ORDER/**

7174

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	
1	110	110	D103-858-B	B41592
2	21	21	D3299-3	B41829

PICKED UP BY / RECU: \_\_\_\_\_

En cas de perte ou de dommages dû à la la valeur intrinsèque de certaines responsabilit  se limitera   deux fois la valeur du traitement des pieces perdues ou endommag es.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.





# ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

68350

23-Sep-2008

CLIENT/CUSTOMER:

PORT AEROSPACE LTD.

700 ABERDEEN STREET

AWKESBURY, ONTARIO

NA 1K7

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE

NO. DE COMMANDE:

PURCHASE ORDER/

7174

Nadcap

Chemical Process  
Nondestructive Testing

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
	110	110	D103 858-B B41592	MATL AL BLACK ANODIZE PER MIL-A-8625 TYPE II CLASS 2 ALL OVER
		21	D3299-3 B41829	MATL AL BLUE ANODIZE PER MIL-A-8625 TYPE II CLASS 2 ALL OVER

On certifie que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Work cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient  
temperatures.

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air  
ambiant.

Signature/Signed: \_\_\_\_\_

Directeur de la Qualité / Q.A. Manager

